

Date: Wednesday, 07/01/2009 8:52:10 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L FWD X-TUBE
Job Number : 44139	
Estimate Number : 10553	
P.O. Number :	Part Number : D206667103
This Issue : 07/01/2009 S.O. No. :	Drawing Number : D206-667-143 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision : C
Previous Run : 44213	Material :
Written By :	Due Date : 27/01/2009 Qty: 1 Um: Each

Checked & Approved By : JUD 09.01.07

Comment :
 Est Rev:F 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJ/JLM
 Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD
 verified by:
 Est Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified by:
 EC
 Est Rev:I 08-12-15 add magnobond DD verified by:EC
 Est Rev J 09.01.06 ECN 08-562 EC verified by: DD

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC

DOCUMENT CONTROL



for JUD 09/01/08

09/01/08



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

+ DSI 9439 Rev. A

ECN 08-59B

2.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0 D206667103TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B-44378*

MB 09-01-09

4.0 BENDING

BENDING MACHINE - SKIDTUBES



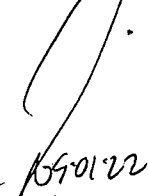




Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206B-fw and Folio FT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-103 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AP Date: 09/02/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44139</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.01.09	4	Tube wide & high after bending. SEE DIM SHEET	 09.01.09 per QS1042	ACCEPTABLE	 09.01.09 per QS1042	 09.01.22	 09.01.09 per QS1042	 09.01.22

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Drawing Name: 206L FWD X-TUBE

Job Number: 44139

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



09.01.09

Comment: DIMENSIONAL CHECK OF X-TUBES

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



PD

Comment: LANDING GEAR RESOURCE 1

- 1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.
- 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.
- 4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.
- 5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.
- 6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143.
Note: Fwd side has 3x top holes.
- 7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.
- 8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.
- 9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143
- 10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143
Inside of Cuff(Donot engrave on outside of tube)

MB
09-01-13

MB
09-01-14

MB
09-01-13

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



MB
09-01-14

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S
09/01/14 (40)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S
09/01/14 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-103 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 09/02/13

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44139</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/14	# 67	Durbin inspection found on only 1 cuff that the Drill Bit touched the other side of the inside of the cuff causing	CP 09.01.14 per OS 042	Debur / buff as best possible. Acceptable.	MB 09-01-14	S 09/01/14	CP 09.01.14 per OS 042	S 9/1/14
		a small dimple. R.C. employee went too deep with the 0.323" drill while drilling the 3rd 0.323" hole on the aft side of the cuff						S 9/1/14

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Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



PO 8000 ML 09-01-19



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

ML 09/01/19 (C)

12.0

QC5

INSPECT WORK TO CURRENT STEP



ML 09/01/19



(1)

Comment: INSPECT WORK TO CURRENT STEP

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ML 09 01 19 (T)

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 09-01-20

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 43176

ML 09 01 19

16.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 42784

ML 09 01 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44139

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D28911

2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

38122

ml 09 01 21

18.0

D3595063395

rubber cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION .63" x 3.95"

B 42998

ml 09 01 21

19.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

109269

ml 09 01 21

20.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

109297

ml 09 01 19

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



(P70) →

Comment: LANDING GEAR RESOURCE 1

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.

A/R Magnobond 6398 : 109900

ml 09 01 21 (1)

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

ml 09 01 22 (1)


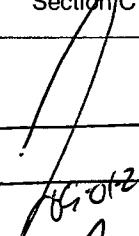



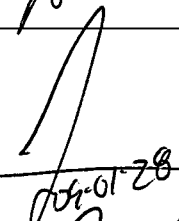
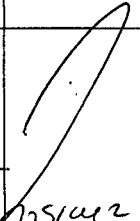


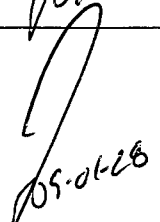
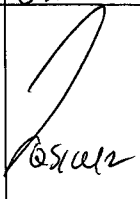
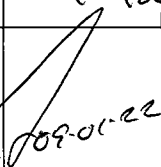
3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

ml 09 01 19 (1)

Re-installed: ml 09 01 27 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-103 PAR #: N/A Fault Category: Prod / Crosshatch NCR: Yes No DQA: LD Date: 09/02/13
 Resolution: re-work Disposition: re-work QA: N/C Closed: LD Date: 09/02/13

NCR:44139		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/20	# 21.3	During assembly it was found that on one cuff only the D206-667-103 nut plate was installed too high.		Drill out incorrectly installed carefully.	ML 09 01 21			
				→ inspect from visually	ML 09 01 21			
				→ Reinstall MB20601A0403 B# 1092A7	ML 09 01 21			
		RE employee had the nut plate positioned too high. Human error.		→ Touch up head of nuts to match cuffs as per AS2005.	ML 09 01 21			
09-01-22	21.1	Upon inspection the supports were found to be 26" apart instead of 26.16". Too narrow for customer installation. Supports slid inward during clamping. R.C. Human error.		carefully remove the supports & magnabond. re-position as per the dwg.	ML 09 01 27			

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Job Number: 44139

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M110363

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: 109297

26.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M110363

27.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M109661

28.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109752

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L FWD X-TUBE

Job Number: 44139

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 09/02/03

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: 53

PPP Rev: 5

9/2/03

80

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

Job Completion



U 09.02.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

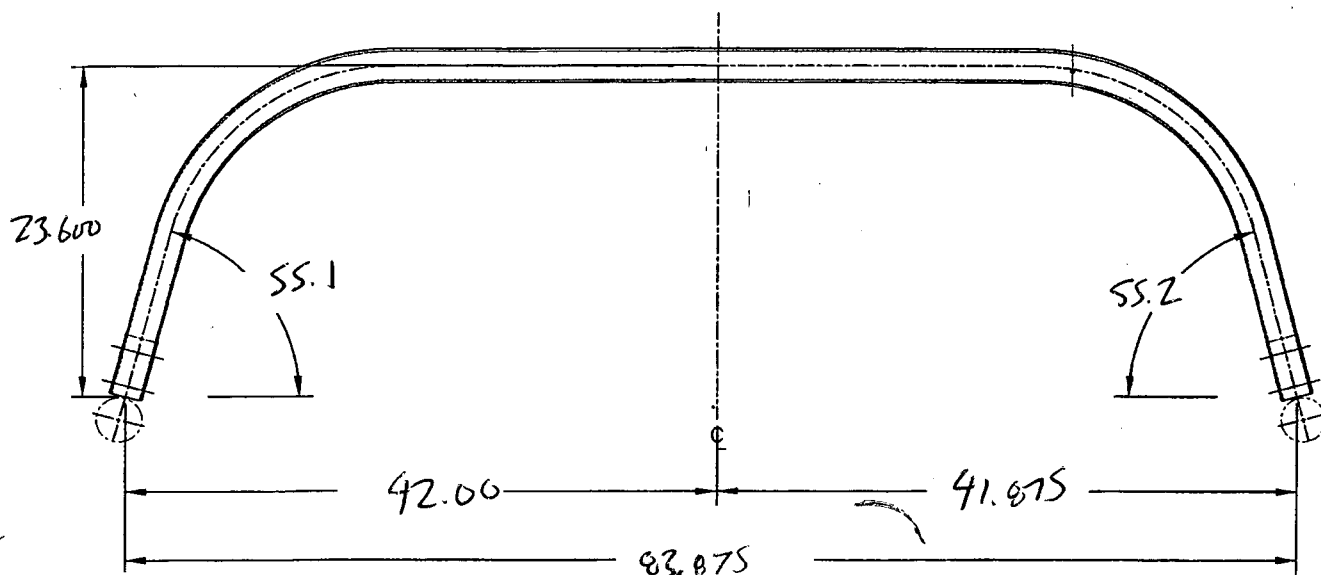
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44139
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: <i>EC</i>		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
OK <i>09.01.09</i>

QC15 Inspection	<i>09.01.09</i>
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 15.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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WORK ORDER
NO. 44137

RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D

C

B

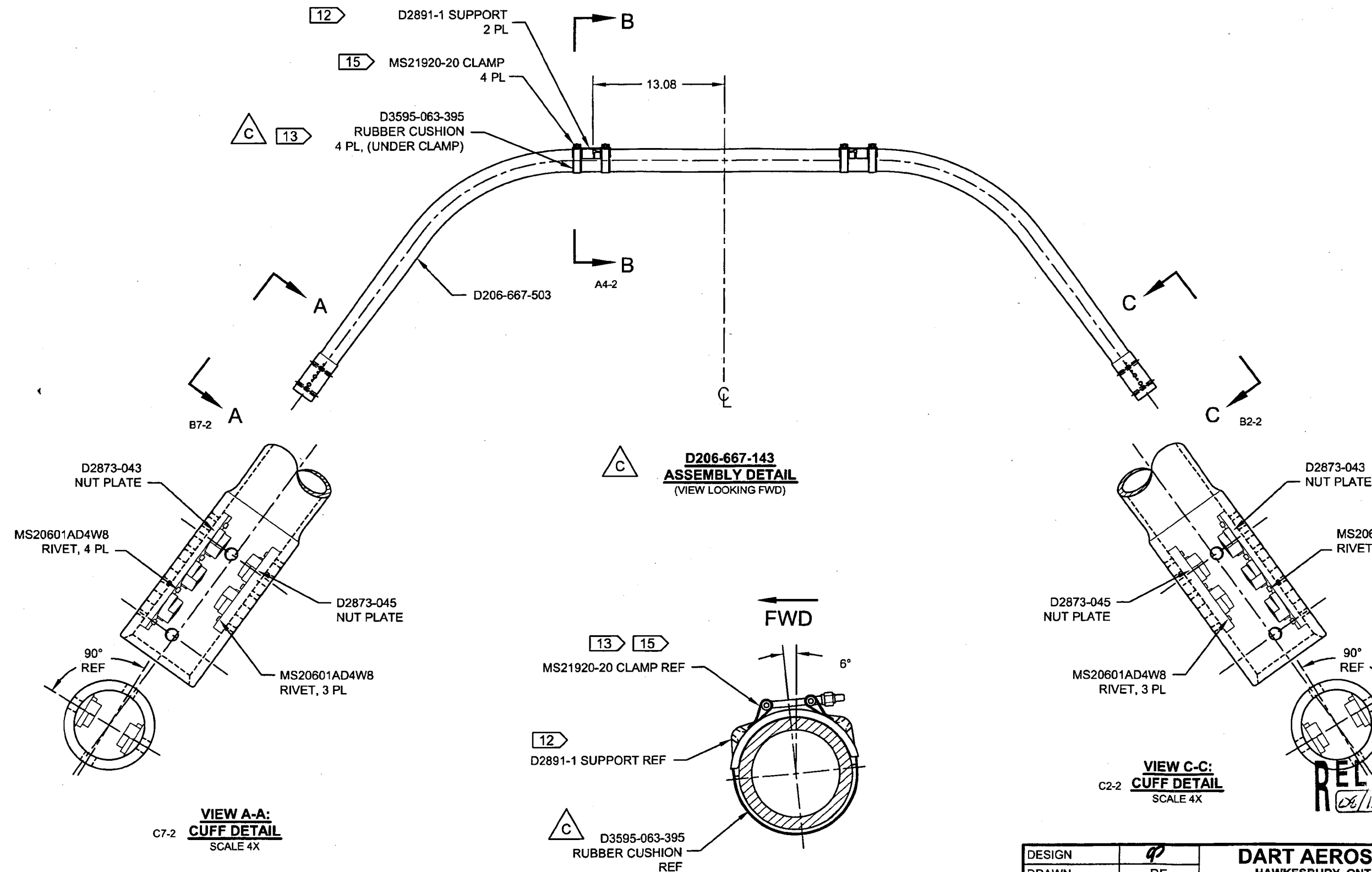
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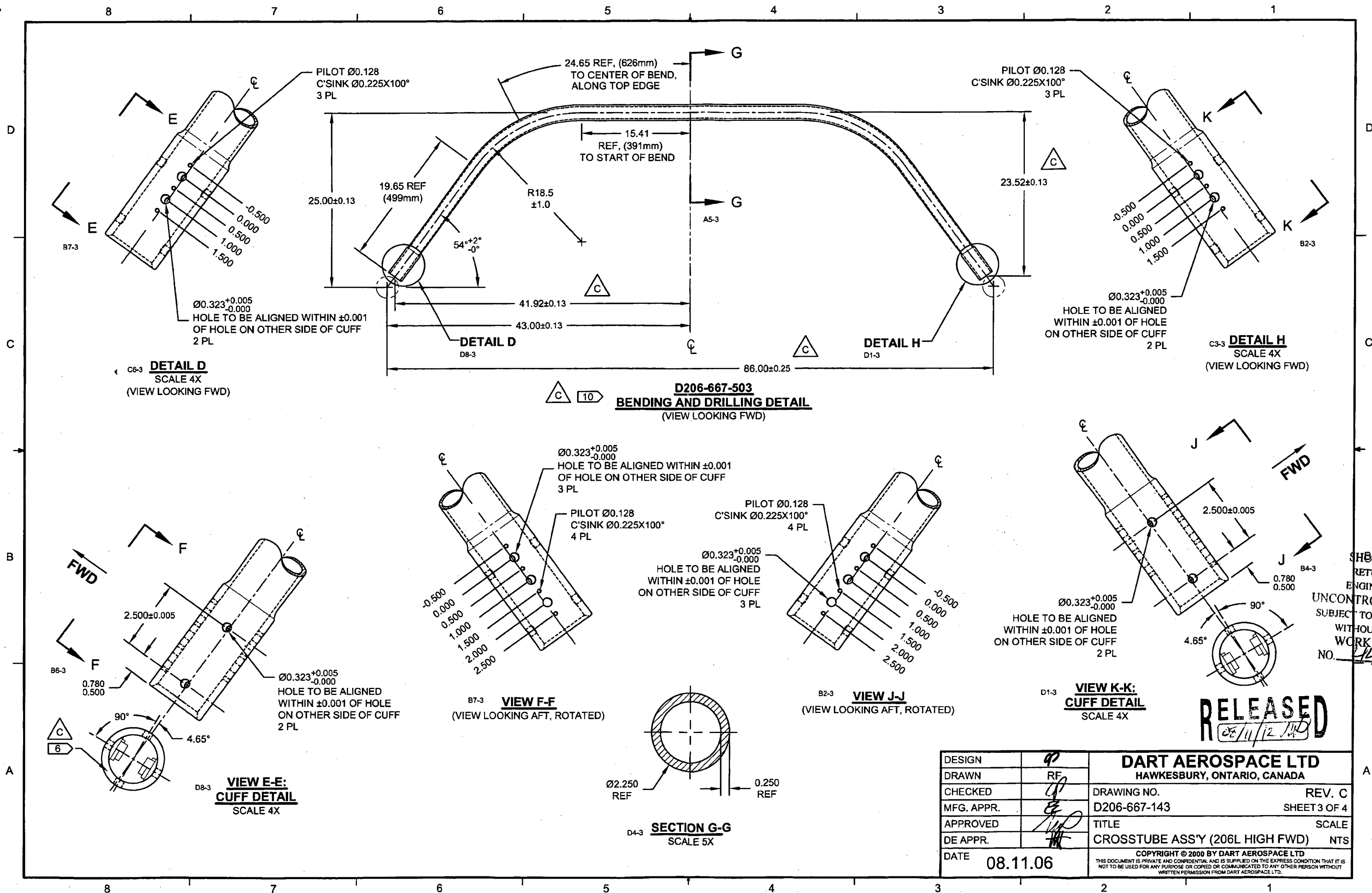
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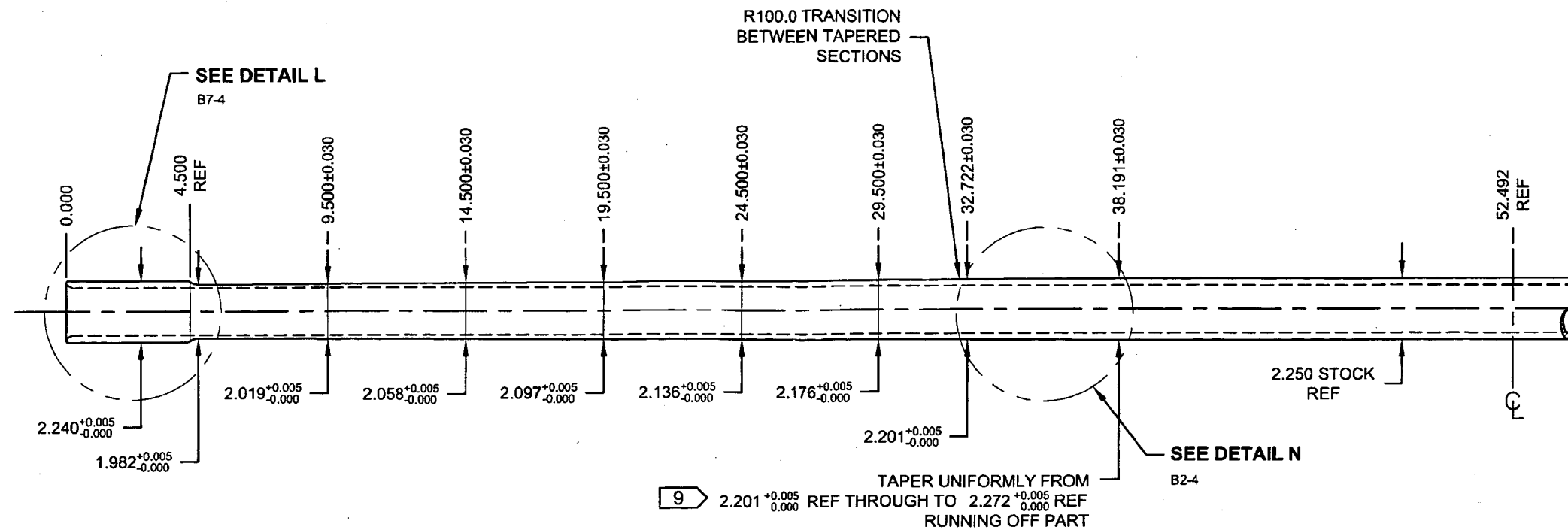


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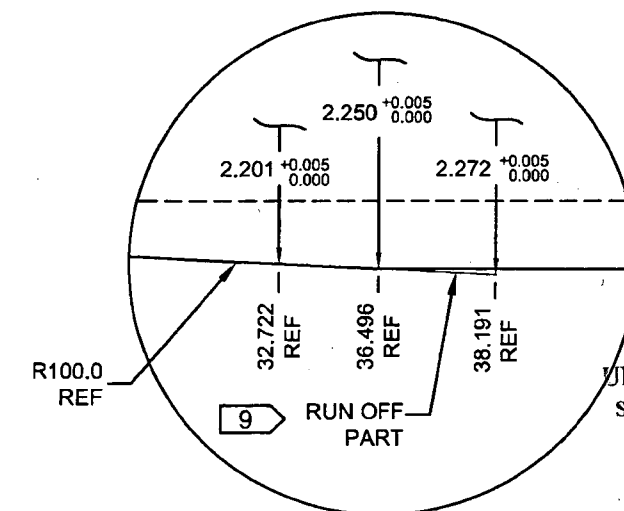
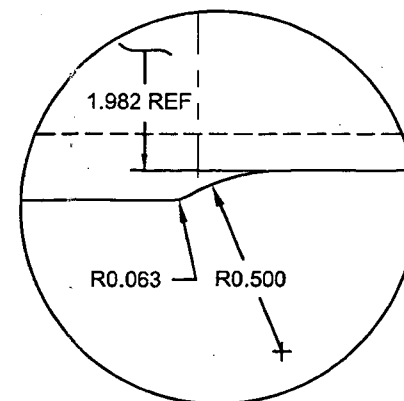
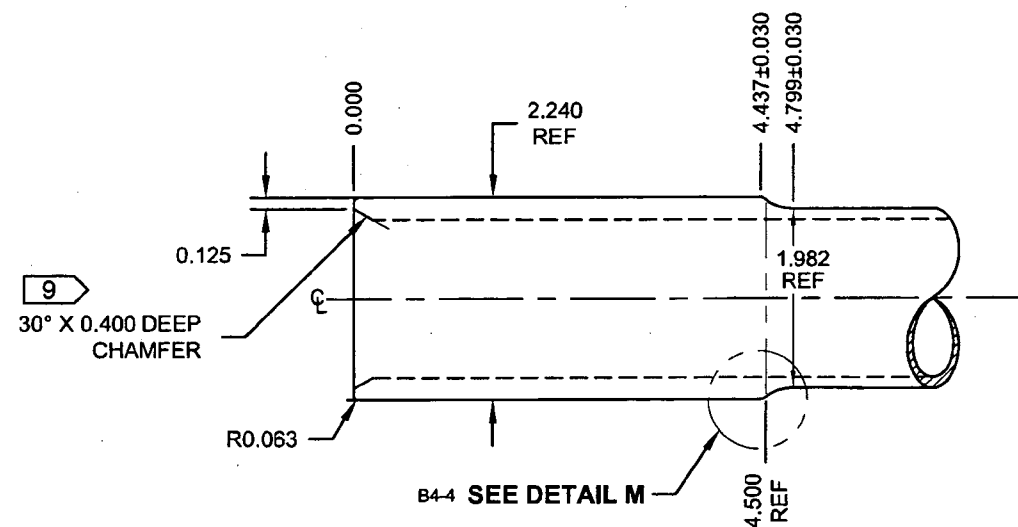
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. C
MFG. APPR.	90	D206-667-143	SHEET 2 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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NO. 44131



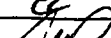



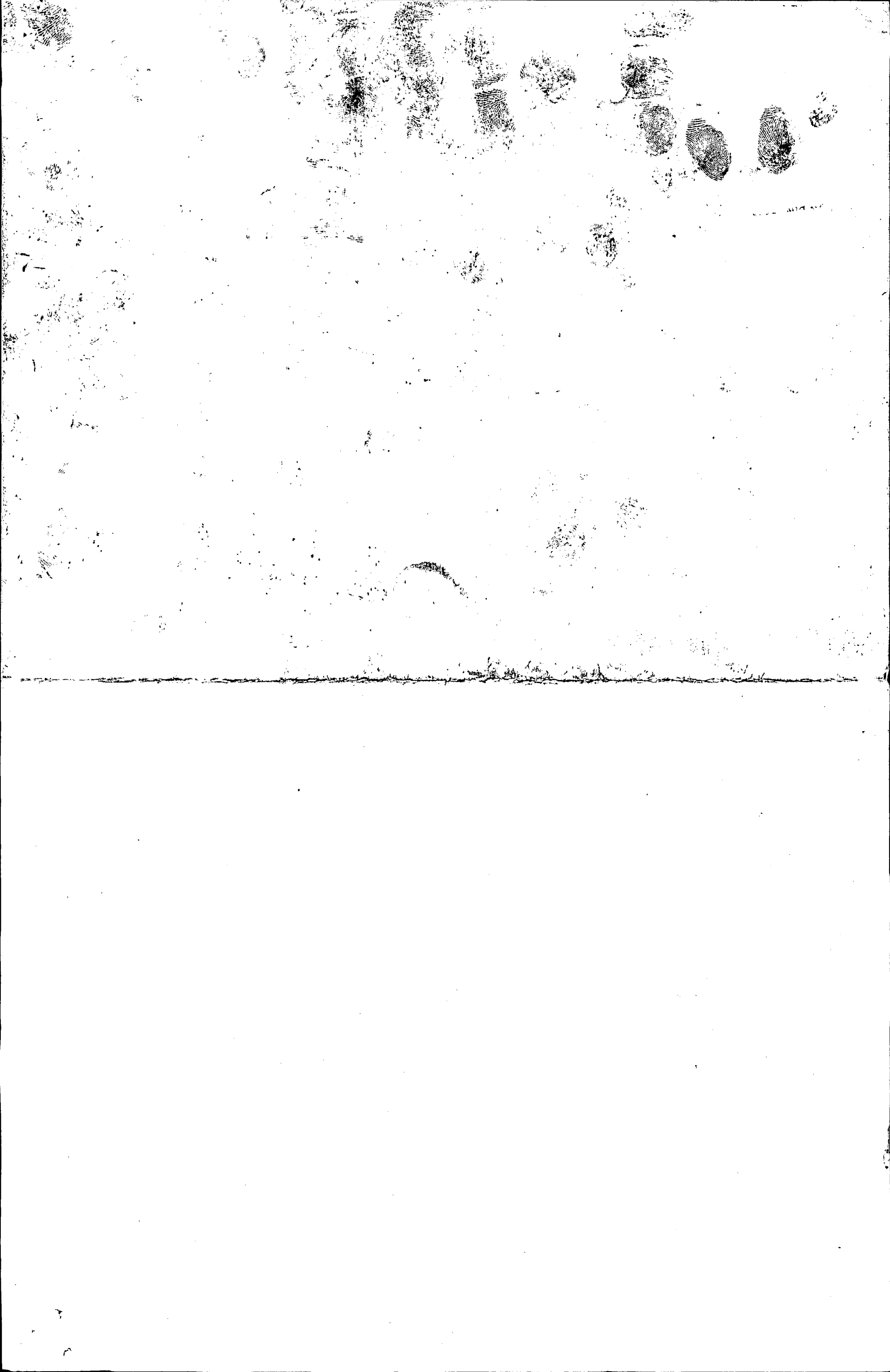
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WORK ORDER
NO. 44139

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DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-143	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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LIQUID PENETRANT TEST REPORT

P- 1493

PAGE 1 OF

CLIENT DART AEROSPACE DATE JAN 16-2009 TIME AM ☐ P
ATTENTION LINDA LAELLE ACUREN JOB NO. 188-09-001278
ADDRESS 1270 ABERDEEN ST PO/VO NO. 18000
HAWKES BURY ONT WORK LOCATION MAIN SHOP-HAWKES
ACCEPTANCE STD. ASTM1417 REV./DATE 200
PROJECT X-TUBES Q51-038
ITEM(S) EXAMINED 7 ITEMS. FLOUORESCENT DIE

JOB DESCRIPTION PROCEDURE No. LT-XXXX REV./DATE TECHNIQUE No. LT-XXXX-XXX REV./DATE
PART NO. MATERIAL ALODINED ALUM. THICKNESS
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EM
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT
PENETRANT Z167 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SKD52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE FEB
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE ME
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☐ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)
PART IDENTIFICATION
1 - B-44125-443052 SC 1 44215
~~1 - B-54450-44193~~
1 - B-44155-44192 ✓
1 - B-44378-44139 ✓
1 - B-44379-44140 ✓
1 - B-43330-44384 ✓
1 - B-43051-44214 ✓
AN INDICATION WAS LOCATED ON THIS PIECE. WILL BE SANDED TO SMOOTH, AND REEXAMINED AT LATER DATE.
md 09-01-19

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as well as data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Julie Dawson DTR # 19804
TECHNICIAN (SIGNATURE): Mike Johnston REPORT REVIEWED BY:
NAME (PRINT): Mike Johnston NAME INIT
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL II SNT LEVEL CGSB LEVEL SNT LEVEL
CGSB REG. NO 0666 CGSB REG. NO

**ACUREN**

Daily Time Report

E- 19804

Form dated Sep 2005

Client: DART AEROSPACE
 Contact: LINDA LACELLE
 Location: 1270 ABERDEEN
 Description: X-TUBES, 7 PCS.
 Report #'s: F. L. PI

W.O. # 188-09-001278
 Job #: 188-09-001278
 Day: Sun Mon Tues
 P.O. #: —
 Vehicle #: 579

Date: JAN-16-2009
 Wed Thurs (Fri) Sat
 W.O #: 188-09-001278
 Camera #: —

Name	Specialist	Tech.	CEDO	Assistant	Start Time	Total Hours		Total Hours				KM	LOA	OTM	TLD NO.	RADIATION SAFETY CHECKLIST								
						Travel	Worked	ST	OT	DT	SP					SAFETY CHECKS						Daily DRD Readings		
																C/C	S/E	S/C	B/S	C/L	C/S			
M. Johnston		✓			11:30	AM	2	3					200											
						AM																		
						AM																		
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						AM																		
						AM																		
						AM																		

RADIOGRAPHIC UNIT PRICING

Weld Diameter																								
Schedule / Thickness																								
Quantity																								

Film: _____ Pcs. 2 3/4 x 17"
 _____ Pcs. 3 1/2 x 17"
 _____ Pcs. 4 1/2 x 17"
 _____ Pcs. 14" x 17"
 _____ Pcs. _____

Consumables: WET FLUORESCENT.
AS PER —
 Equipment: _____

Client Representative: J. Dawson

Place a check mark in each safety check area as completed	
C/C	CAMERA CHECK
S/E	SAFETY EQUIPMENT CHECK
S/C	SURVEY METER CHECK
B/S	BARRIER & SIGN INSTALLED
C/L	CAMERA LOCKED & SECURELY STORED
C/S	CAMERA SURVEYED AFTER EACH USE

EXPENSES

NOTES

ACUREN 1-877-299-2857

Oakville (905) 825-8595 • Fax (905) 825-8598
 Sarnia (519) 336-3021 • Fax: (519) 336-8220
 Sudbury (705) 522-1849 • Fax (705) 522-9926
 Halifax (902) 497-3870 • Fax (902) 445-5090
 North Bay (705) 840-8107 • Fax (705) 476-6683
 Val D'Or (819) 856-6789 • Fax (819) 825-9564

Cambridge (519) 622-3112 • Fax (519) 622-1326
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